February-07-13 8:24:54 AM

\*96835

Ship March 25

Page 1

Item ID: D3935-4 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Pylon Wall Protector, RH **Start Date:** 2/07/13 Start Qty: 10.00 \*10\* **Cust Item ID:** Required Date: 3/22/13 Req'd Qty: 10.00 **Customer:** Reference: Run Start Process Plan: MLJ Date: 13-02-07 Tooling: Approvals: Date: Stop \_\_\_\_ Date:\_\_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** D3935 В 100 0.00 \*100\* JM13-2-21 Waterjet Memo 0.00 FLOW CNC Waterjet 1-Cut as per Dwg D3935 Dwg Rev: Prog Rev: 2- Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 \*110\* QC Memo 0.00 Quality Control

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** Yes / No NCR: QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Crosstube Engineering Skid-tube Water Jet Rework Prod. Eng. Coor. Quality Machining Small Fab Part No. Scrap Finishing Rec/Store/Packaging Other Thermoforming Use-as-is Composite Supplier Work Order Update Large Fab NCR No. Action Sign & Description of work order update Initial Root Verification QC Inspector **Chief Eng** Date Description or Non-conformance Cause Date Step Qty Doc/Data Equip/Tooling Operator Material Setup Other **Process** Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Ovalized Pressure/Forced Bend Grain Bending Over/Under tolerance Temperature/Cure BOM/Route Hardware Centre Not Concentric to O/S Part Incorrect Weld Broken/Damaged Inspection Incomplete Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs Maintenance Part Moved Contamination Cuffs Positioned Wrong Countersink Mislabeled Heat Treat Other Power Loss/Surge **Cut Too Short** Misread Inspection Strip in Tube Drill Holes Offset Ripples in Bend

Out of Calibration

Out of Sequence

Outside Dimensions

**Turning Sequence** 

Wave/Twist in Tube

**Torque Waves in Extrusion** 

Drawing

Finish

Folio

February-07-13 8:24:54 AM

\*96835\*

Page 2

Item ID: D3935-4 Accept \*N900040100\* Setup Start **Revision ID:** Pylon Wall Protector, RH Item Name: **Start Date:** 2/07/13 **Start Qty: 10.00** Cust Item ID: Required Date: 3/22/13 Req'd Qty: 10.00 **Customer:** Reference: Run Approvals: Process Plan: Date: Tooling: Date: Date: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool # Plan Tool ID Accept Reject Reject Insp. Work Center ID Description Run Hours Code Qty **Qty** Number Stamp 120 QC8- Inspect parts - second check \*120\* Memo Quality Control 130 Identify as per dwg & Stock Location: 0.00 \*130\* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 13/2/2645 MF 13-2-26 \*140\* 0.00 Memo Quality Control

											DQA:	Date	:	
NCR:	⁄es	/ No				WORK ORDER NON-	-co	NFORN	ANCE / UP	DATE		0-4-	-	
											QA Closed:	Date	:	
						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Work Orde	er: -	***				Rework	$\neg$		Skid-tube	Crosstube	ן	Water Jet	Engineering	
Part N	u o					Scrap	$\dashv$	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
Faili	۱U					Use-as-is	$\dashv$		noforming	Finishing	4	re/Packaging	Other	
NCR I	No.					Work Order Update	┪		Large Fab	Composite	1	Supplier	7	
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Cause		Date	Step	Qty	,	or Non-conformance	CI	hief Eng	Desc	cription	Date	Verification	QC Inspector	
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	Bending					Bend BOM/Bouts	$\vdash$	Grain Hardware		-	⊣	tolerance	Temperature/Cure	
	Centre Not Concentric to O/S					BOM/Route Broken/Damaged	⊢	-		<u> </u>	Over/Under tolerance Part Incorrect		Weld	
	Cracks Crushed/Crimped					Burrs	-	Inspection Incomplete			Part Lost/M	<b>-</b> -	Wrong Stock Pulled	
	$\vdash$	1	crimpea		-	Contamination	H	Instructions Incomplete/Unclear  Maintenance			Part Moved	· ·		
	$\vdash$	Cuffs	<b>-+</b>		-	Countersink	<u> </u>	Mislabeled			Positioned Wrong			
	-	Heat Tre Inspection		Tuba	-	Cut Too Short	<b> </b>	Misrea		<u> </u>	Power Loss		Other	
l	1	hushecuc	ur anib ii	i i ube	<u> </u>				-	L.				

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## **Picklist Print**

February-07-13 8:24:58 AM

Work Order ID: 96835

\*96835\*

Parent Item:

D3935-4

\*D3935-4\*

Parent Item Name: Pylon Wall Protector, RH

**Start Date: 2/07/13** 

Required Date: 3/22/13

JMB-2-21

Start Qty: 10.00

\*\*

Required Qty: 10.00

**Comments:** 

IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	11.6273	8.048	<del>84.7157</del> 9	·		

\*MI FXS 125-F60029-04\*

<b>Location</b>	Loc Qty	Loc Code
MAT019	11.6273	
121803	11-6273	

124654

124654

											DQA:	Date:		
NCR:	⁄es	/ No				WORK ORDER NON-	COI	VFORN	MANCE / UP	DATE	QA Closed:	Date:		
Work Orde	er:					DISPOSITION				AGAINST DE	PARIMENI	PROCESS		
	•			, ,		Rework	7		Skid-tube	Crosstube	]	Water Jet	Engineering	
Part N	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
	-					Use-as-is	1	Therm	oforming	Finishing	Rec/Sto	e/Packaging	Other	
NCR I	۷o.					Work Order Update	]		Large Fab	Composite	]	Supplier		
Root				[	Descri	tion of work order update	Т	nitial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	cription	Date	Verification	QC Inspector	
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Material			ļ											
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Process														
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Training	$oxed{oxed}$							:						
Unapproved			<u> </u>		L	<del></del>	<u> </u>							
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Landi	ng (	ì			_	General		٦, ٠		_	۱	<del></del>	J	
	Bending					Bend	$\vdash$	Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced	
	Centre Not Concentric to O/S				o/s	BOM/Route	-	Hardware			Over/Under	Temperature/Cure		
	<u></u>	Cracks			_	Broken/Damaged	$\vdash$	-i '	or incomplete	// the sleep	Part Incorre	<u> </u>	Weld	
	<u> </u>	Crushed/	Crimped		-	Burrs	-	-1	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	<b> </b>	Cuffs	_		-	Contamination	$\vdash$	Mainte		-	Part Moved Positioned Wrong			
	-	Heat Tre		<b>T</b> 1	<u> </u>	Countersink	$\vdash$	Mislabe		<del> </del>	Power Loss/		Other	
1	1	Hospectic	n Strip in	lube		Cut Too Short	ı	Misread	ı		ILOMEL FO22/	Juige	I O STITE!	

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DART AEROSPACE LTD	Work Order:	96835
Description: Pylon Wall Protector, RH	Part Number:	D3935-4
Inspection Dwg: D3935 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

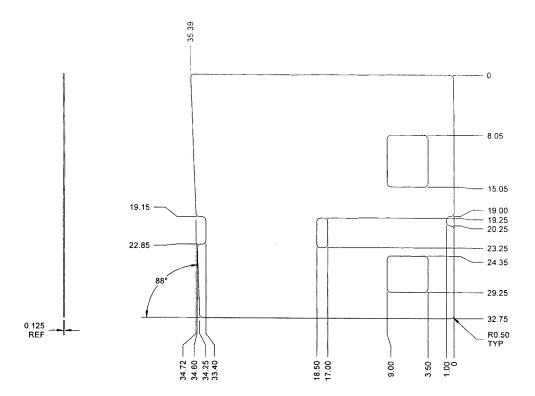
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.68	+/-0.030	5,68'			V	Tomos
12.68	+/-0.030	12.66	_		T	JAMO6
18.75	+/-0.030	18.75	-		Ť	
19.00	+/-0.030	19.000	_		T	
20.25	+/-0.030	20.25	_		T	
22.75	+/-0.030	22.75"	_		7	
23.73	+/-0.030	28.33"	-		1	
28.63	+/-0.030	28.63	_		Ť	
32.75	+/-0.030	39.75"	-		~	
1.00	+/-0.030	10000	_		V	
3.50	+/-0.030	3.50-	-		V	******
9.00	+/-0.030	9.000	-		V	Produtor
14.70	+/-0.030	14.70	-		T	
16.20	+/-0.030	16.20m	-		<b>T</b>	
33.40	+/-0.030	33.40"	_		T	
34.25	+/-0.030	34.25"	-		T	4,- 8,
34.60	+/-0.030	34.60	_		7	
34.72	+/-0.030	34.72	_		Ť l	
22.85	+/-0.030	22.85h	-		T	
19.15	+/-0.030	19.15"	-		Ť	• •
35.39	+/-0.030	35,39"	_		1	
0.125	+/-0.010	0.126"	~		V	
			CAC			

Measured by: Jm Audited by: 15 Prototype Approval: N/A

Date: 13-3-21 Date: 13 2 2) Date: N/A

Rev	Date	Change	Revised by	Approved
Α	09.11.17	New Issue	KJ KJ	1/1



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С

**D3935-1 PYLON WALL PROTECTOR, LH** (TEXTURED SIDE SHOWN)

NOTES:
1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04

REF DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-1" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 5.79 lbs
8) CHECK PER TEMPLATE DT8922

ADD -3, -4 (SHEET 3, 4) 09.08.19 NEW ISSUE Α HS 09.04.21 REV. DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3935 MFG. APPR. SHEET 1 OF 4 TITLE APPROVED SCALE **PYLON PROTECTOR** DE APPR. NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD

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NOT TO BE USED FOR ANY PURPLISE OR COMPLETED TO ANY OTHER PERSON WITHOUT DATE 09.08.19

